

Date: Monday, 26/05/2008 9:53:51 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)	
Job Number :	39476	Part Number :	D2574	
Estimate Number :	10534	Drawing Number :	D2574 REV E	
P.O. Number :		Project Number :	N/A	
This Issue :	26/05/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	E	
First Issue :	/ /	Type :	MACHINED PARTS	
Previous Run :	38923	Material :		
Written By :		Due Date :	10/06/2008	Qty: 10 Um: Each
Checked & Approved By :	<u>JLD 08.5.23</u>			
Comment :	Est Rev: I As Per RevE 06-01-27 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574
 Ensure that grain is along 5.00" length
 Batch No: 34874

JLD 08/07/06

(10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 39476 Double check by: JLD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

JLD / J.L 08/07/06

(10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

JLD / J.L 08/07/06

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLD / J.L 08/07/06

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/05/2008 9:53:51 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/07/07 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 0807-07 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:00

OVEN TEMPERATURE:

320

FINISH TIME:

11:30

Q12

08/07/07 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-07-07 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: (433)

8/7/1

(10x) SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08 (10)

Job Completion



h 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39476
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.446		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.998	8.000	8.000		
F	0.490	0.510		.495	.498	.501	.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	.500	.497	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	.567	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.122		
P	0.115	0.135		.123	.123	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.251	.251		
S	0.115	0.135		.124	.123	.121	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.228		
V	0.230	0.250		.242	.241	.238	.239		
W	0.115	0.135		.125	.130	.132	.132		
X	0.307	0.312		.310	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.364	.363	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.627	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.249	.246	.245		
AE	1.500	1.520		1.508	1.512	1.513	1.515		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.251	.250	.249	.249		
AI	2.000	2.020		2.001	2.004	2.004	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>
Date:	08/07/05	Date:	08/07/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	39976
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	7.998	7.999	7.999		
F	0.490	0.510		.502	.503	.502	.502		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.497	.499	.499		
J	1.174	1.184		1.180	1.178	1.178	1.180		
K	0.558	0.578		.568	.565	.567	.568		
L	1.174	1.184		1.180	1.178	1.178	1.180		
M	1.365	1.375		1.360	1.368	1.368	1.370		
N	2.495	2.505		2.499	2.500	2.500	2.499		
O	4.119	4.129		4.123	4.121	4.122	4.122		
P	0.115	0.135		.126	.125	.126	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.251	.251	.252		
S	0.115	0.135		.123	.127	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.228		
V	0.230	0.250		.240	.241	.241	.241		
W	0.115	0.135		.134	.134	.133	.134		
X	0.307	0.312		.310	.310	.309	.308		
Y	0.760	0.765		.760	.760	.761	.761		
Z	0.352	0.372		.361	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.626	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.248		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.251	.251	.251		
AI	2.000	2.020		2.003	2.003	2.003	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>mf</i>
Date:	08/07/06

Audited by:	<i>S</i>
Date:	08/07/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>

DART AEROSPACE LTD	Work Order: 39476
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

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B	1.745	1.755		1.750	1.750				
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D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.504	.506				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.567	.569				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
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P	0.115	0.135		.127	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.252	.252				
S	0.115	0.135		.126	.126				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.243	.243				
W	0.115	0.135		.134	.134				
X	0.307	0.312		.307	.308				
Y	0.760	0.765		.762	.761				
Z	0.352	0.372		.363	.362				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.626	.627				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.249	.247				
AE	1.500	1.520		1.511	1.510				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.253	.253				
AI	2.000	2.020		2.004	2.003				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	<i>mp</i>
Date:	08/07/06

Audited by:	<i>S</i>
Date:	08/07/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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